

Date: Monday, 11/21/2005 12:39:49 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 24859	
Estimate Number : 10798	
P.O. Number : N/A	Part Number : D3159043
This Issue : 11/21/2005 S.O. No. : N/A	Drawing Number : D3159 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : R & D SM/MED FAB	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 12/21/2005 Qty: 4 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER.	
Comment : Est A 02.05.13 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 3.0391 sf(s)/Unit Total : 12.1565 sf(s)

Stack of 7

Blank size: 2.560" x 1.545" x .063" thick.

Grain along 1.545"Matl: 6061-T6 .063" thick

Batch M18556

14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA238

stack of 7

M18556 06/02/19

14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M18556 06/02/19

14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06-02-19

14

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr break all sharp edges .005 to 0.010

JAD 06/02/20

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 12:39:49 PM
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Job Number: 24859

Part Number: D3159043

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-C'sink holes as per Dwg D3159

SB 06/02/21 (14)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per drawing (Note: -044 OPPOSITE)

SB 06/02/21 14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/21 (14)

8.0

MS21061L06

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nutplate

Pick:

Qty Part number Description Batch

1 MS21061L06 Nutplate

M19085

9.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIVET

Pick:

Qty Part number Description Batch

2 MS20426AD3-4 Rivet

M15786

SB 06/02/23 14

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg.

SB 06/02/23 14

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-24 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 19 Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3159043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 5T410

Rec'd 2/24 (14)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/02/27 (14)

Job Completion



U 06-02-27 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

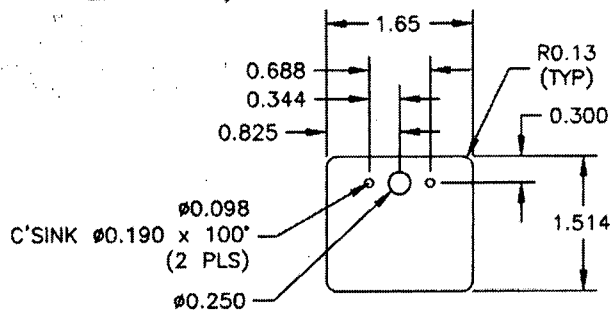
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

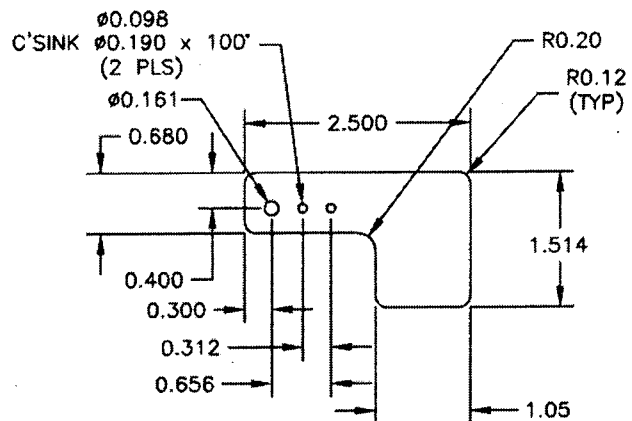
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3159	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

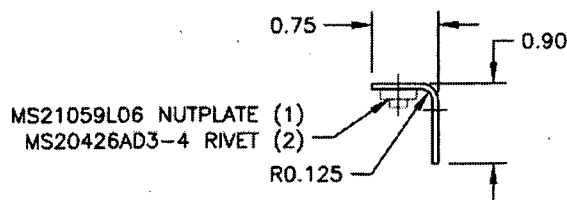
RELEASED
04.11.23



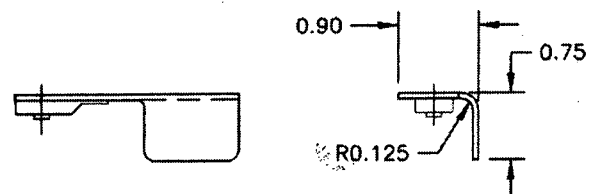
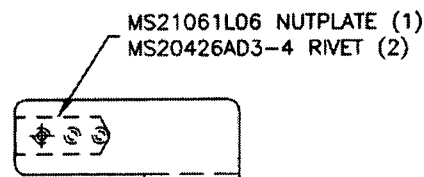
D3159-1 BRACKET FLAT PATTERN



D3159-3/-4 BRACKET FLAT PATTERN



D3159-041 BRACKET ASSEMBLY



D3159-043 BRACKET ASSEMBLY (SHOWN).
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE)).
REPLACES PREMIER P/N B30-23000-260

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024859	Department Code:	
Project Name	: D3159-043	Burden Flags	: NNNNNNNN
Project For	: WK551	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3159-043	Invoice Number	:
Description	: Bracket Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-21-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok*for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

